

Date: Thursday, 5/3/2007 11:30:14 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)						
Job Number	: 32166									
Estimate Number	: 10531									
P.O. Number	: N/A		Part Number	: D2572						
This Issue	: 5/3/2007		S.O. No.	: N/A		Drawing Number	: D2572 REV E			
Prsht Rev.	: NC					Project Number	: N/A			
First Issue	: N/A		Type	: MACHINED PARTS		Drawing Revision	: E			
Previous Run	: 32077					Material	: N/A			
Written By	:					Due Date	: 5/22/2007			
Checked & Approved By	:		: 05/07.05.03				Qty:	12	Um:	Each
Comment	: Est: 1 02-10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ									

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101005	7075-T7351 8.25X5.0X2.5 
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2572 Ensure that grain is along 5.00" length Batch No: <u>B25350</u>	 <i>ML 07/06/10</i>
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 
	Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No: <u>B32166</u> Double check by: <u>SC</u>	
	1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.	<i>ML/SC 07/06/10</i>
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE 
	Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572	 <i>ML/SC 07/06/10</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 

Page 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/06/19
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/3/2007 11:30:14 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 32166

Part Number: D2572

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SD 01.06.12

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SD

07.06.12

12

7.0 POWDER COATING POWDER COATING



M 104144



13

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BL/M- 07.06.18

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



FD



07/06/18 12

Comment: INSPECT POWDER COAT

9.0 PACKAGING 1 PACKAGING RESOURCE #1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/06/18 12

10.0 QC21 FINAL INSPECTION/W/O RELEASE



12

Comment: FINAL INSPECTION/W/O RELEASE

07/06/19

Job Completion



07.06.19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	32166
Description: Saddle, Fwd Inboard				Part Number:	D2572
Inspection Dwg: D2572 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.746	1.747	1.747	1.749		
C	3.495	3.505		3.497	3.500	3.500	3.506		
D	1.745	1.755		1.746	1.747	1.747	1.749		
E	7.990	8.010		7.999	8.001	8.001	8.001		
F	0.490	0.510		0.496	0.495	0.491	0.495		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.499	0.498	0.499	0.500		
J	1.174	1.184		1.175	1.177	1.175	1.178		
K	0.558	0.578		0.565	0.565	0.565	0.571		
L	1.174	1.184		1.175	1.177	1.175	1.178		
M	1.490	1.500		1.492	1.494	1.492	1.495		
N	2.495	2.505		2.495	2.497	2.492	2.500		
O	3.869	3.879		3.871	3.871	3.873	3.872		
P	0.115	0.135		0.125	0.125	0.126	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.250	0.250	0.249	0.249		
S	0.115	0.135		0.123	0.124	0.127	0.130		
T	0.178	0.198		0.186	0.188	0.188	0.198		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.236	0.235	0.237	0.239		
W	0.115	0.135		0.127	0.130	0.131	0.135		
X	0.307	0.312		0.310	0.309	0.310	0.307		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.364	0.367	0.367	0.367		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.625	0.628	0.626	0.630		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.242	0.246	0.247	0.249		
AE	1.375	1.395		1.386	1.385	1.382	1.385		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.246	0.248	0.248	0.249		
AI	2.000	2.020		2.002	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: Er
Date: 07/06/08

Audited by: 2.06.12
Date: 5/1

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	2/11

DART AEROSPACE LTD				Work Order:	32166
Description: Saddle, Fwd Inboard				Part Number:	D2572
Inspection Dwg: D2572 Rev. E				Page 1 of 1	

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			Recorded Actual Dimensions						
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.439	0.439	0.439	0.439		
B	1.745	1.755		1.748	1.749	1.749	1.749		
C	3.495	3.505		3.499	3.506	3.499	3.500		
D	1.745	1.755		1.748	1.749	1.749	1.749		
E	7.990	8.010		8.002	8.002	7.999	8.000		
F	0.490	0.510		0.501	0.503	0.503	0.503		
G	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.500	0.501	0.500	0.500		
J	1.174	1.184		1.179	1.178	1.179	1.179		
K	0.558	0.578		0.569	0.576	0.569	0.569		
L	1.174	1.184		1.179	1.178	1.179	1.179		
M	1.490	1.500		1.494	1.498	1.495	1.494		
N	2.495	2.505		2.500	2.499	2.500	2.500		
O	3.869	3.879		3.872	3.871	3.872	3.872		
P	0.115	0.135		0.125	0.125	0.124	0.124		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.249	0.249	0.248	0.249		
S	0.115	0.135		0.131	0.130	0.130	0.129		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.240	0.240	0.241	0.236		
W	0.115	0.135		0.133	0.133	0.134	0.136		
X	0.307	0.312		0.309	0.309	0.309	0.308		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.370	0.365	0.367	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.629	0.630	0.630	0.636		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.248	0.247	0.257	0.247		
AE	1.375	1.395		1.385	1.386	1.384	1.387		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.250	0.249	0.251	0.247		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject				1					

Measured by: *JMK*
Date: 07/06/09

Audited by: *SD*
Date: 07.06.12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>JK</i> <i>JLM</i>	

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B	1.745	1.755		1.749	1.749	1.749	1.748		
C	3.495	3.505		3.500	3.499	3.499	3.500		
D	1.745	1.755		1.749	1.749	1.749	1.748		
E	7.990	8.010		7.999	8.000	8.001	8.002		
F	0.490	0.510		0.501	0.502	0.503	0.502		
G	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.501	0.501	0.500	0.502		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.569	0.570	0.570	0.571		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.493	1.495	1.495	1.495		
N	2.495	2.505		2.499	2.500	2.499	2.500		
O	3.869	3.879		3.872	3.872	3.872	3.872		
P	0.115	0.135		0.125	0.125	0.125	0.125		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.249	0.249	0.249	0.250		
S	0.115	0.135		0.128	0.125	0.123	0.122		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.966	2.960	2.966		
V	0.230	0.250		0.234	0.236	0.235	0.235		
W	0.115	0.135		0.133	0.134	0.134	0.131		
X	0.307	0.312		0.310	0.309	0.309	0.309		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.362	0.362	0.360	0.357		
AA	0.470	0.530		0.500	0.500	0.500	0.506		
AB	0.615	0.635		0.630	0.630	0.630	0.632		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.247	0.247	0.246		
AE	1.375	1.395		1.389	1.386	1.387	1.387		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.266	0.260	0.260	0.266		
AH	0.240	0.260		0.246	0.246	0.247	0.248		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: *Amr*
Date: 07/06/10

Audited by: *SD*
Date: 07.06.12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>2/2</i>	<i>SD</i>



